

Work Order ID 120947

June-16-14 1:14:01 PM

120947

Page 1

Item ID: D044-715-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cargo Mirror Installation
 Start Date: 6/09/14 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 6/16/14 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: 1406-17 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D3243 | Rev A | | | | | | | | |
| IIN-D044-715 | Rev A | | | | | | | | |
| 100 | Document Control | 0.00 | | | | | | | |
| *100* | DOCUMENT CONTROL | | | | | | | | |
| DC | Memo | 0.00 | | | | | | | |
| Doc.Control -USB or Paperwork | Photocopy bluefile & type labels per PPPD044-715-011 | | | | | | | | |
| | | | | | | | | | |
| 110 | Pick Kit | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |

DAS
06
9-89

JUL 21 2014

2

DAS
31
9-89

DAS
33
9-89

14-07-18

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|---|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
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| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|--|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design <input type="checkbox"/> | | | | | | | | | |
| Doc/Data <input type="checkbox"/> | | | | | | | | | |
| Equip/Tooling <input type="checkbox"/> | | | | | | | | | |
| Handling/Pre <input type="checkbox"/> | | | | | | | | | |
| Material <input type="checkbox"/> | | | | | | | | | |
| Operator <input type="checkbox"/> | | | | | | | | | |
| Offset/Setup <input type="checkbox"/> | | | | | | | | | |
| Process <input type="checkbox"/> | | | | | | | | | |
| Supplier <input type="checkbox"/> | | | | | | | | | |
| Training <input type="checkbox"/> | | | | | | | | | |
| Transport <input type="checkbox"/> | | | | | | | | | |
| Unapproved <input type="checkbox"/> | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

Picklist Print

June-16-14 1:13:59 PM

Page 1

Work Order ID: 120947

120947

Parent Item: D044-715-011

D044-715-011

Parent Item Name: Cargo Mirror Installation

Start Date: 6/09/14

Required Date: 6/16/14

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A04.02.18New issueKJ/JLM
IPP Rev:B 06-04-28 Manufactured on Water Jet JLM
IPP Rev:C 08-06-10 as per ECN1195p DD verified by:EC IPP Rev:D
11.05.04 remove FE-032-EF DD verified by:EC

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|-----------------|-------------|--------------|---------------|-------------------|-------------------------------|
| D3243-041 Bracket | | Manufactured | No | | | 110 | Each | 3.0000 | 1 | 2 | | | |
| ** | | | | | | | | | | | | DAS 33 9-89 | DAS 31 9-89 |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | |
| | | | | ST228 | | | 3 | | | | | | |
| | | | | 109862 | | | 3 | | 109862 | | | | |
| D1048 Clamp | | Manufactured | No | | | 110 | Each | 16.0000 | 2 | 4 | | | |
| ** | | | | | | | | | | | | DAS 33 9-89 | DAS 31 9-89 |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | |
| | | | | GA | | | 16 | | | | | | |
| | | | | 115372 | | | 16 | | 115372 | | | | |
| D1049 Saddle | | Manufactured | No | | | 110 | Each | 40.0000 | 2 | 4 | | | |
| ** | | | | | | | | | | | | DAS 33 9-89 | DAS 31 9-89 |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | |
| | | | | GA | | | 40 | | | | | | |
| | | | | 115603 | | | 20 | | 115603 | | | | |
| | | | | 117825 | | | 20 | | | | | | |
| D2010-104 ARM | | Manufactured | No | | | 110 | Each | 5.0000 | 1 | 2 | | | |
| ** | | | | | | | | | | | | DAS 33 9-89 | 14-07-10 DAS 31 9-89 |
| | | | | <u>Location</u> | | | <u>Loc Qty</u> | <u>Loc Code</u> | | | | | |
| | | | | ST220 | | | 5 | | | | | | |
| | | | | 110086 | | | 5 | | 110086 | | | | |

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | |
|--|--|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence |
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| <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other | | |

Picklist Print

June-16-14 1:14:00 PM

Work Order ID: 120947

120947

Parent Item: D044-715-011

D044-715-011

Parent Item Name: Cargo Mirror Installation

Start Date: 6/09/14

Required Date: 6/16/14

Start Qty: 2.00

Required Qty: 2.00

D2011-101

Manufactured No

110

Each

46.0000

1

2

DAS

33

9-89

DAS

31

9-89

D2011-101

Mirror 6"

DAS
06
9-89

Location

Loc Qty

Loc Code

FG

2

106348

2

ST179

44

113569

1

117810

43

117810

AN3-4A

Purchased

No

110

Each

329.0000

4

8

DAS

33

9-89

DAS

31

9-89

AN3-4A

Bolt

DAS
06
9-89

Location

Loc Qty

Loc Code

ST350

281

m128429

100

m128739

56

m129163

125

ST511

48

m127044

48

128429

AN526C1032R10

Purchased

No

110

Each

119.0000

4

8

DAS

33

9-89

14-07-18

AN526C1032R10

Screw

DAS
06
9-89

Location

Loc Qty

Loc Code

FP001

6

108062

6

ST505

113

m128712

113

128712

DAS

31

9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | |
|--|--|---|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> |
|--|--|---|

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|---|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other _____ _____ _____ |
|--|--|---|---|

Picklist Print

Page 3

June-16-14 1:14:00 PM

Work Order ID: 120947

120947

Parent Item: D044-715-011

D044-715-011

Parent Item Name: Cargo Mirror Installation

Start Date: 6/09/14

Required Date: 6/16/14

Start Qty: 2.00

Required Qty: 2.00

ALS4-1032-130

AELS4-1032-130 Purchased

No

110

Each

7,234.000

4

8

N *AI S4-1032-130*

Rivnut

DAS
06
9-89

**

DAS
33
9-89

DAS
31
9-89

Location

Loc Qty

Loc Code

FP001

7129

M128649

7129

ST279

48

M128211

48

st510

57

M126109

57

128649

NAS1149D0332J

Purchased

No

110

Each

3,202.000

4

8

N *NAS1149D0332.J*

Washer

DAS
06
9-89

**

DAS
33
9-89

14-0748

Location

Loc Qty

Loc Code

ST294

263

m128606

263

ST510a

2939

m128612

2939

128612

DAS
31
9-89

June-16-14 1:14:00 PM

Shop Packet Print

Page 3

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
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| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

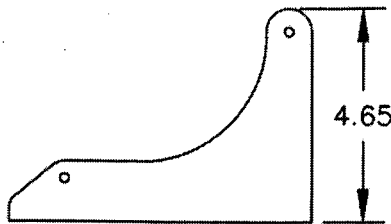
| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
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| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | |
|--|--|---|
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| | | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge |
| | | <input type="checkbox"/> Pressure/Forced Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |

DART

| | | | |
|-------------------------------|--------------------------------|--|------------------------|
| DESIGN <i>CP</i> | DRAWN BY <i>CP</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3243 | REV. A SHEET 1 OF 1 |
| DATE 04.01.09 | | TITLE BRACKET | SCALE 1:2 |
| A | 04.01.09 | NEW ISSUE | |



R0.188 (TYP)

INSTALL
FE-032-EF INSERTS
(4 PLACES)2.75 ± 0.030
0.000

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO 120947
14-06-17

D3243-1 BEND DETAIL/
D3243-041 ASSEMBLY
SCALE 1:4

RELEASED
04.02.03

8.581
8.206
7.706

GRAIN
DIRECTION

11.920
11.420
Ø0.201
(TYP 4
PLACES)

Ø0.290
(TYP 4
PLACES)

1.375

5.273

3.714

**D3243-041 BRACKET ASSEMBLY
(D3243-1 BRACKET)**

- 1) MATERIAL: 6061-T6, 0.063 THICK
(QQ-A-250/11, REF DART SPEC
M6061T6S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT
PER DART QSI 005 4.1
POWDER COAT BLACK (4.3.5.7) PER
DART QSI 005 4.3
- 3) BREAK ALL SHARP EDGES 0.005 TO
0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018
UNLESS OTHERWISE NOTED

4.214
R0.25 (TYP)
3.339
R0.38
(TYP)

5.494

R2.75
(TYP)

D3243-1
FLAT PATTERN

R0.50
(TYP)

0.500
0.000

6.560
5.810
5.360

0.750
0.500
0.000

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JUL 21 2014

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REFERENCE ONLY
04S
06
089

IIN-D044-715

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2. GENERAL NOTES

COMPATIBILITY

Compatibility of this installation with the aircraft is the **responsibility of the installer**. Ensure that this installation does not conflict with a previous modification.

CONTINUING AIRWORTHINESS

This installation should be maintained in accordance with the Instructions for Continued Airworthiness ICA-D044-715.

3. INSTALLATION INSTRUCTIONS

To install the Dart Cargo Mirror Installation on the R44 skidtube:

1. Locate the D3243-041 Bracket with approximately 0.38" (10mm) space between the top of the skidtube and the bracket, as shown in Figure 2. Transfer drill the 4 holes from the bracket to the centerline of skidtube and enlarge to 10/64" (Ø0.297"). Deburr holes and wet install ALS7-1032-130 inserts using MIL-P-85582 or MIL-P-23377 primer.
2. Install the D3243-041 Bracket on the skidtube using the AN3 hardware. The bolts should be sealed with Sikaflex-241/-291 or Proseal 890 or MIL-S-8802 Class 'B2' sealant before installing as per Figure 2.
3. Install remaining hardware per Figure 2 as required. Adjust the angle of the D2010-104 Arm and tighten the AN526C1032R10 screws to secure arm.
4. To adjust the mirror: loosen (DO NOT REMOVE) the three adjustment screws shown in Figure 2, reposition the mirror, then tighten the screws.

4. WEIGHT AND BALANCE

| Installation | Weight | LATERAL | | LONGITUDINAL | |
|---------------------------|---------|---------|------------|--------------|------------|
| | | Arm | Moment | Arm | Moment |
| D044-715-011 | 1.3 lb | 41.7 in | 54.2 lb-kG | 32.0 in | 41.6 in-lb |
| Cargo Mirror Installation | 0.59 kg | 1.06 m | 0.63 m-kG | 0.81 m | 0.48 m-kG |

5. PARTS LIST

| Qty | Part Number | Description |
|-----|---------------|---|
| X | D044-715-011 | CARGO MIRROR INSTALLATION |
| 2 | D1048 | Clamp |
| 2 | D1049 | Saddle |
| 1 | D2010-104 | Arm |
| 1 | D2011-101 | Mirror |
| 1 | *D3014-1 | Locknut |
| 1 | D3243-041 | Bracket |
| 4 | ALS7-1032-130 | Insert (or AKS7-1032-130, AKS4-1032-130, ALS4-1032-130) |
| 4 | AN3-4A | Bolt |
| 4 | AN526C1032R10 | Screw (or AN526-1032R10) |
| 4 | AN960JD10L | Washers |
| 1 | *AN960JD416L | Washer |

* PARTS ARE INCLUDED WITH D2011-101 MIRROR

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Revision: **A**

Date: 04.01.20

Work Order ID 120947

June-16-14 1:14:01 PM

120947

Page 1

Item ID: D044-715-011

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Cargo Mirror Installation

Start Date: 6/09/14

Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/16/14

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 14-06-17

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3243

Rev A

IIN-D044-715

Rev A

100

Document Control

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPPD044-715-011

CHG003

MLJ

14-07-18

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging